

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014661**Date Inspected:** 14-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 8AE-8BE

ABF Request No: 06122010-3

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (cross beam side) of OBG segment 8AE and 8BE. Inspection was carried out on repair areas. The weld designations are as follows.

SEG046-013 (OBG 8AE-8BE, B.P to S.P - Cross beam side)

OBG SEGMENT 8BW-8CW

ABF Request No: 06132010-1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the deck panel splice weld between OBG segment 8BW and 8CW. Inspection was carried out on repair areas. The weld designations are as follows.

OBW8A-003, 002, 004 (OBG 8BW-8CW, D.P)

OBG SEGMENT 8BW-8CW

ABF Request No: 06142010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the side panel splice weld between OBG segment 8BW and 8CW. Inspection was carried out on repair areas. The weld designations are as follows.

OBW8C-002 (OBG 8BW-8CW, S.P, Counter weight side)

OBG SEGMENT 9AW

ABF Report No: UT-9W-029

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (cross beam side). The weld designations are as follows.

CA056-006 (OBG 9AW, D.P to E.P, cross beam side)

OBG SEGMENT 8CW

ABF Report No: UT-8W-044

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (cross beam side). The weld designations are as follows.

SEG047*-044 (OBG 8CW, D.P to E.P, cross beam side)

OBG SEGMENT 9AW

ABF Report No: UT-9W-029

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (cross beam side). The weld designations are as follows.

SEG049-014 (OBG 9AW, S.P to B.P, cross beam side)

OBG SEGMENT 8CW

WELDING INSPECTION REPORT

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ABF Report No: UT-8W-043

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between bottom panel and side panel (cross beam side). The weld designations are as follows.

SEG047B-047 (OBG 8CW, S.P to B.P, cross beam side)

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8AE-8BE

ABF Request No: 06122010-3

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the welds between side panel and bottom panel of OBG segment 8AE and 8BE (Cross beam side). Inspection was carried out on repair areas. Weld identification number were.

SEG046-013 (OBG 8AE-8BE, B.P to S.P - Cross beam side)

During the magnetic particle inspection ABF QA Inspector found 3 linear indications.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer